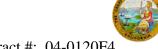
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 6<u>9.yy</u>

DAILY PROJECT JOURNAL

Prime Contractor: American Bridge/Fluor Enterprises, a JV Report No: DPJ-000235 **Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Dated: 17-Aug-2007

Location: Changxing Island, Shanghai, China

Submi	ittals(New / Total): CWR	's: 0 / 0	HSR's: 0/0	NCR's: 0/2	
Item	Title	Detail			
1	Major component movement	Continued	Continued welding of 77m Tower Mock-up. Welding included tack		
		welding ski	welding skin plates C, D and E. Work was suspended (see below).		
		Weld PQR	Weld PQR HP2007149-1, welding is in progress.		
2	Meetings attended	QA met wi	QA met with ABF at 1500 to discuss the schedule for tomorrow:		
		Sand Blast	2 plates for the 89m and 1 plate:	for the 114m Tower Mock-up.	
		Cut and bev	vel 1 plate the for 114m Tower M	Mock-up on Saturday and 1 plate	
		for the 77m	and 1 plate for the 114m Tower	Mock-ups on Sunday.	
		Welding of	the PJP splice welds on the 77m	Tower Mock-up skin plates	
		will be base	ed upon approval of the appropri	ate WPS.	
		Additionall	y, ABF informed QA that the Al	BF Mock-ups were complete and	
		that ZPMC	would be submitting additionl V	VQCP addendum for welder	
		qualificatio	ns on site.		
3	Key conversations At the 1		meeting, ABF gave QA the Tov	wer Skin Plate PJP WPS to	
		review. Th	e joint detailed was a CJP (B-U3	B) instead of a PJP. It was also a	
		FCAW WP	S instead of a SAW WPS. QA a	asked ABF about this, they	
		spoke with	ZPMC and found out that joint of	letail was a mistake, but that	
		ZPMC deci	ded to perform FCAW on the ro	ot and SAW for the remaining	
		passes. The	e Mock-up shop drawings detail	a SAW weld for this joint. We	
		discussed v	why ZPMC was changing the join	nt and if this was how they	
		planned on	welding in production. ZPMC i	nformed QA and ABF that they	
		plan to use	SAW in production, but that sind	ce SAW PQR HP200748 was	
		rejected ear	lier in the day due to error in the	e listed parameters, they decided	
		to submit th	ne FCAW procedure instead.		
		After ZPM	C discussed this with ABF, they	decided they would correct PQR	
		HP200748	and submit a SAW PJP procedur	re. By this time it was after 4pm	
			med ZPMC that they would not	= = =	
		review and	submit the WPS to Caltrans, and	that they would look at the	

WPS on Monday. ZPMC stated that they were done with the tack welding

DAILY PROJECT JOURNAL

		(Continued Page 2 of 2)	
		and would not be able to weld over the weekend without the SAW	
		procedure. ABF informed QA that no welding would take place this	
		weekend, and they would sort out the WPS and weld joint issues on	
		Monday.	
4	Other important observations	QA observed the machining of Calibration blocks for the Closed-rib UT	
		procedure. QA expressed concerns with the method of machining ZPMC	
		was using (wire band saw). ABF on-site QCM Nate Lindell shared QA's	
		concerns regarding how accurate this method would be for producing the	
		required 10, 20, 30 and 40% notches. Both QA and Mr. Lindell had	
		expected the notches to be produced by EDM (electron discharge	
		machining).	
5	Quality Assurance Inspectors per shift	4 AM (Cuellar, Franco- 1st shift, Brannon- 2nd shift, Acuna- 3rd	
		shift[cancelled])	
		0 PM	
6	Logistics	The three shifts began this morning to cover 24 hours a day a ZPMC were	
		cancelled due to the lack of the appropriate weld procedure.	
		QA (Brannon and McClary) had to take the 5pm ferry, get a ride from ABF	
		to Seasons Villas, and take a taxi from there back to the Marriott.	
Inspected By: McClary, David		Quality Assurance Inspector	
Reviewed By: Lowry, Patrick		QA Reviewer	